



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-4-1

Job Sheet 181087



Part No: C3-4-1

Job Qty: 50 ea

Part Name: Load Beam Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/20/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-4-1 Rev 4 IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		7/31/18	0.00	0.00	Start Up Machining-4		18/08/18
120	Mori Seiki	50 pcs		7/31/18	0.00	5.00	MORI SL-154		18/08/18
130	QC	50 pcs		7/31/18	0.00	0.00	QC2 Machining-5		18/08/18
140	QC	50 pcs		7/31/18	0.00	0.00	QC8 Machining-5		18/08/18
150	Packaging	50 pcs		7/31/18	0.00	0.00	Packaging3-2		18/08/18
160	QC21-SA	50 Ea		7/31/18	0.00	0.00	QC21		21 AUG 14 2018

Part Op 120 - 1-Machine as per folio FC038 FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.000	Bronze C63000 Round Bar 1.000"	2.3300 ft (.0466 ea)	90-Start up Operation	5097370

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.000	2	3	0

Part Specifications

Specifications could not be found.

Plex 7/20/18 9:22 AM Dart.lajeunesse.marie

GA181

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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 www.dartaero.com



Container No: S099320



Part: C3-4-1

Job No: 181087

Serial No/Batch: S099320

Revision: 4

Inspector:

Exp Date:

Instructions:

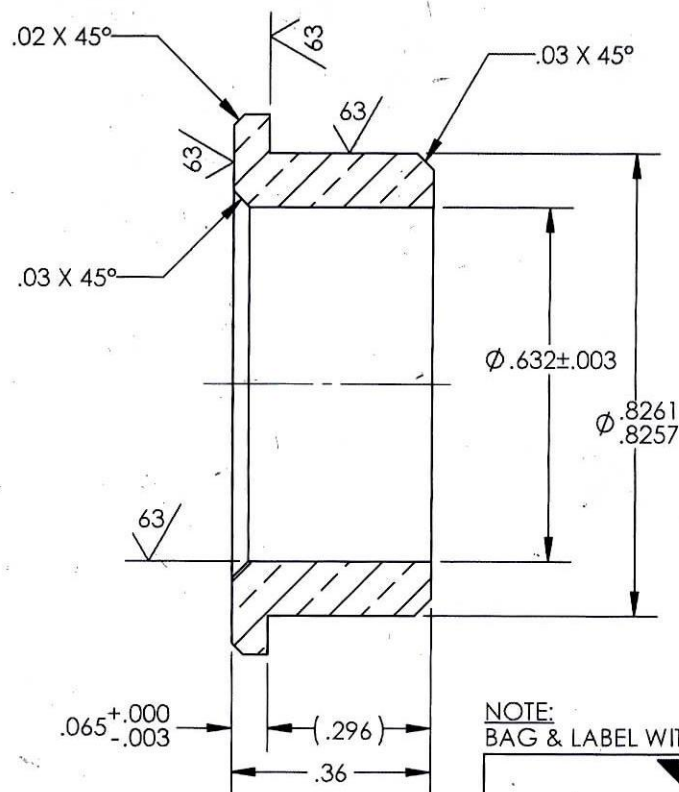
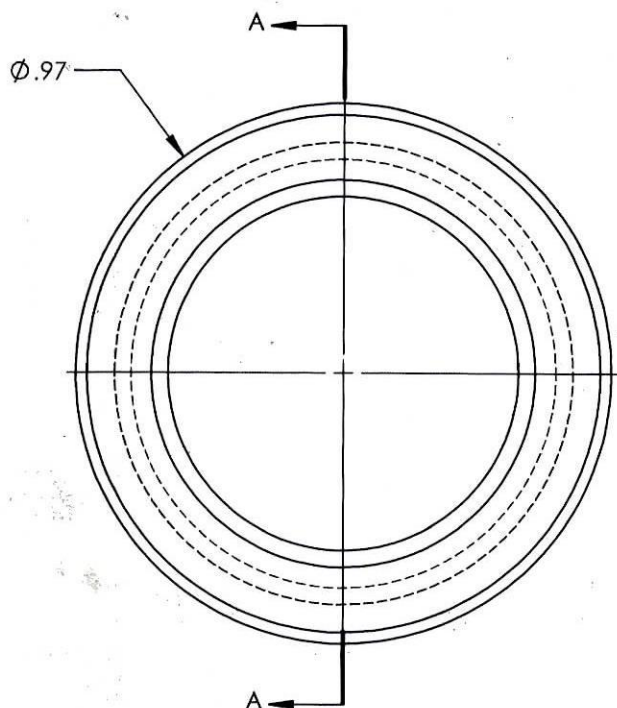
Date: 08/05/18

FAULT CATEGORY

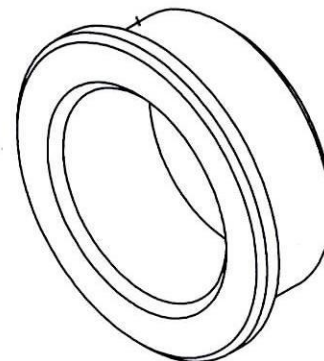
Defect Defective/Unqualified Defective/Unclear	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread	
☐	Misaligned/off center	☐	Turning Sequence	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CH'D Ø.825 +.001/.000 TO Ø.8261 - .8257.	8/15/2012	JAG	
3A	14-0111	CH'D TITLE BLOCK WAS RED. BARN IS DART. ADDED BAG & LABEL NOTE. CH'D DIMENSION TOLERANCE WAS Ø.965 IS Ø.97, WAS .361 IS .36.	8/6/2014	DJN	RW
4	17-0163	CH'D MAT'L WAS AL-BRONZE IS BRONZE 630.	6/23/2017	DPD	JAG



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 181087 M15

18-07-20

NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOAD BEAM BUSHING	
DWG NO. C3-4-1	REV 4
MAT'L BRONZE 630	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH FINISH	.XX ± .01 ANGLES ± 5°
SPEC SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES Ø15 X 45° OR .015R
CHECKED: RJC 06/26/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/06/2017	
SCALE 3:1	DATE 11/12/2001
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-4-1	1	LOAD BEAM BUSHING	BRONZE 630	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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